

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020597**Date Inspected:** 16-Nov-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. Huang Min and Lil Jia**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** BAY 7 and 8 OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector Robert A.DeArmond was present during the time noted above and conducted observations relative to the work being performed.

OBG BAY 8

This QA Inspector observed the following work in progress:

FCAW welding of fillet weld joint(s) located on OBG Bike Paths components identified as BK004A6-063 weld number(s) 043 and 162. Welder is identified as welder no. 054459. The welding variables recorded by ZPMC QC identified as Mr. Liu Fa Wen appeared to comply with applicable WPS(s) WPS-B-T-2133.

FCAW welding of fillet weld joint(s) located on OBG Bike Paths components identified as BK004A6-063 weld number(s) 031 and 032. Welder is identified as welder no. 500479. The welding variables recorded by ZPMC QC identified as Mr. Liu Fa Wen appeared to comply with applicable WPS(s) WPS-B-T-2133.

FCAW welding of partial joint penetration weld joint(s) located on OBG Bike Paths components identified as BK004A8-056 weld number(s) 001, 002, 130, and 007. Welder is identified as welder no. 042218. The welding variables recorded by ZPMC QC identified as Mr. Shen Jian Guo appeared to comply with applicable WPS(s) WPS-B-T-2333-TC-P4-F.

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Magnetic Particle Testing (MT)

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. All components were as listed on NWIT notification no. 07377. The member(s) is/are identified as OBG Bike Path. The weld designations reviewed are as follows:

BK004A3-056-010

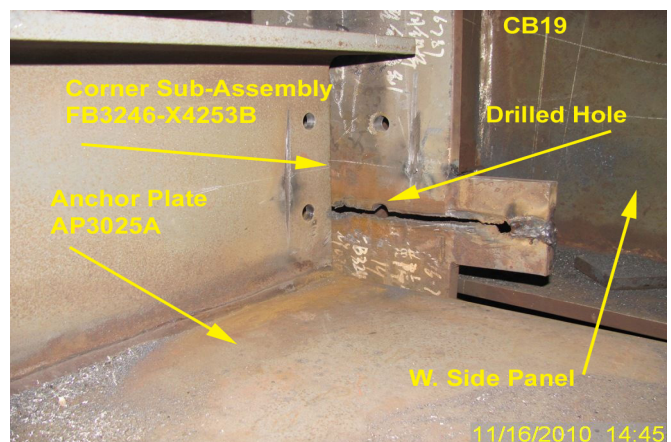
OBG BAY 7

This QA Inspector observed the following work in progress:

During random in process inspection of Orthotropic Box Girder (OBG) member identified as CB19 this QA observed drilling holes through unwelded complete joint penetration weld joint(s) on corner diaphragm sub-assembly identified as (FB3246-X4253B). This QA marked the affected area and informed ZPMC Quality Control (QC) identified as Mr. Xu Hai Yang of this issue. Mr. Yang informed this QA that the drilled holes would be corrected in a manner compliant with the contract documents.

Please see the attached photos

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

As mentioned above between QA and QC concerning this project

Comments

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This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Jim Devy 150-002-6784, who represents the Office of Structural Materials for your project.

Inspected By:	DeArmond,Robert	Quality Assurance Inspector
Reviewed By:	Riley,Ken	QA Reviewer
